

Date: Friday, 28/11/2008 2:54:37 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 43858A	
Estimate Number : 10375	
P.O. Number :	Part Number : D30651
This Issue : 28/11/2008 S.O. No. :	Drawing Number : D3065 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 42344A	Material :
Written By :	Due Date : 20/12/2008 Qty: 50 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est:D 06.04.25 Water jet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1300 sf(s)/Unit Total : 6.4995 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: 110337 IB 8-12-23

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3065

Dwg Rev: B

Prog Rev: B

IB 8-12-23

(65)

2-Deburr as required

IB 8-12-23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-12-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

IB 8-12-23 (65)

counted.

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 28/11/2008 2:54:37 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 43858A

Part Number: D30651

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

09/01/13 (64)

SB 09/01/20 (64)

7.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 09/01/20 (64)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL-9-1-25 (64)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FL 09/01/26 (64)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Sylvie GLA

SS 09/01/26 ACU

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/26 (64)

Comment: FINAL INSPECTION/W/O RELEASE



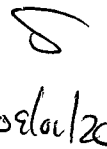
Job Completion



MF
09-01-26

W/O: 43858A		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-1 PAR #: N/A Fault Category: Sm/Med FAB NCR: Yes No DQA: 12 Date: 09-01-26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 2 Date: 09-01-27

NCR: 43858A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/20	6	1 part moved at the bend with the jig bend off		Scrap + destroy NO Replace QTY 10	SB 09/01/20	S 09/01/20	 09/01/20	 09/01/20
		R.C: Process Hummer error						

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43858A
Description: Step Spacer		Part Number: D3065-1
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.253	X			
2.093	+/-0.010	2.084	X			
3.936	+/-0.010	3.938	X			
4.186	+/-0.010	4.192	X			
0.587	+/-0.010	.585	X			
Ø0.128	+0.005/-0.001	.131	X			
R0.125	+/-0.010	.125	X			
3.465	+/-0.010	3.460	X			
Ø1.250	+0.012/-0.001	1.250	X			
0.368	+/-0.010	.366	X			
0.871 (Pitch)	+/-0.005	.871	X			
0.040	+/-0.010	.040	X			

Measured by: IB	Audited by: [Signature]	Prototype Approval: N/A
Date: 8-12-23	Date: 8-12-23	Date: [Signature]

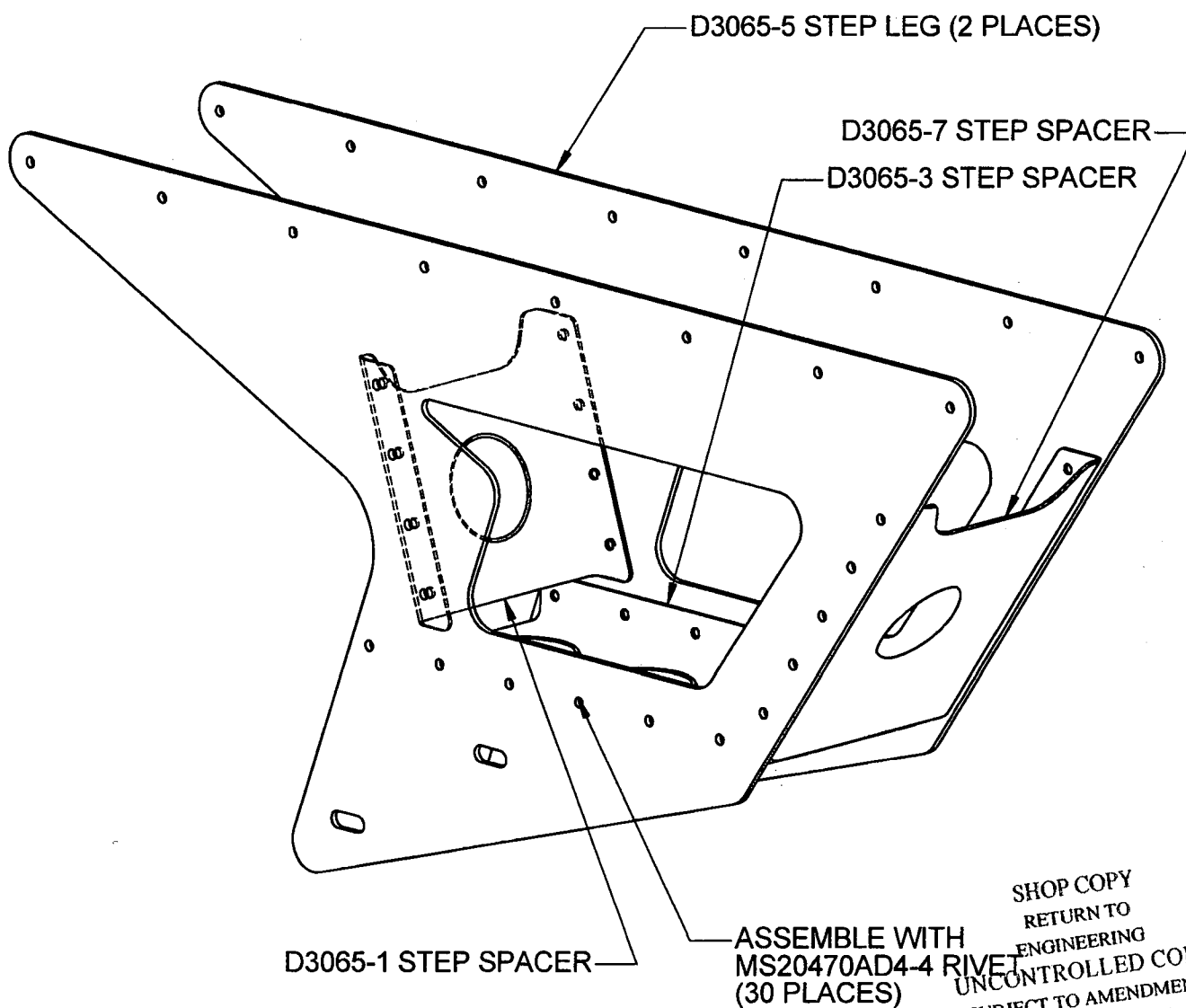
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	[Signature]



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

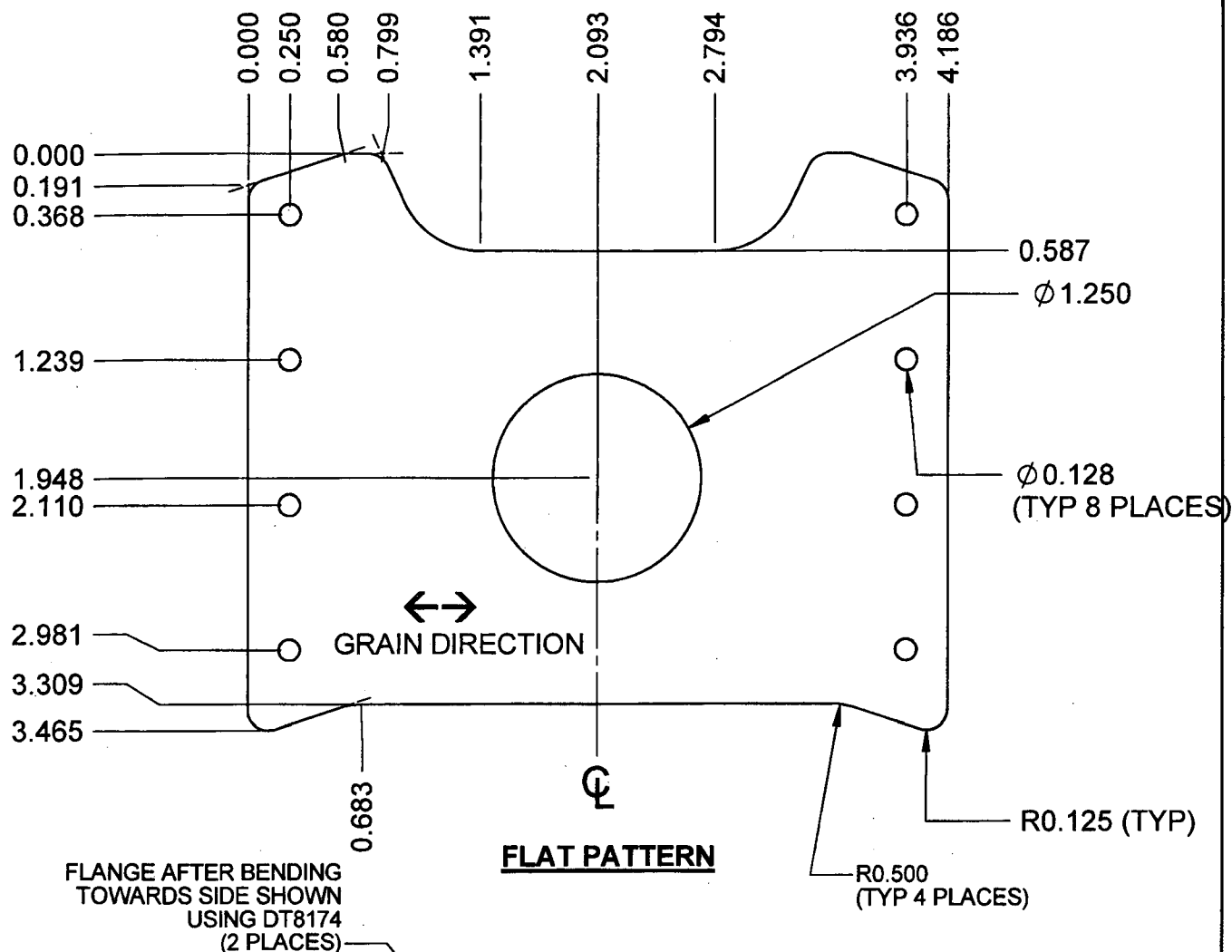
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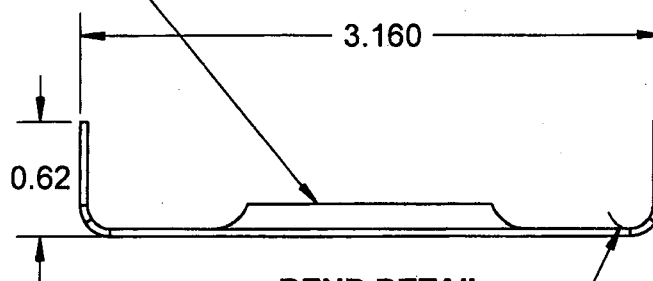


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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



RELEASED

de de-ro



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

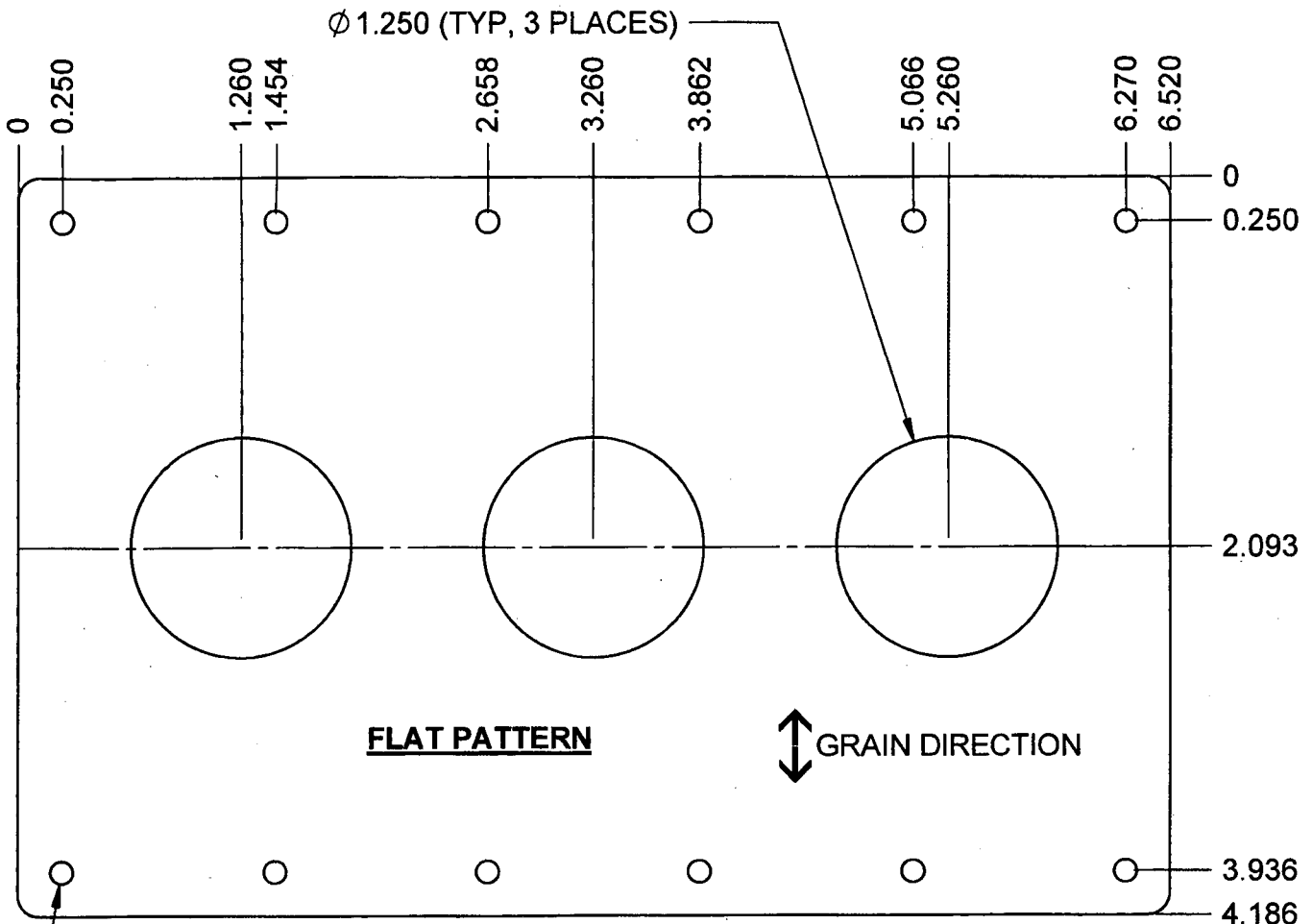
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

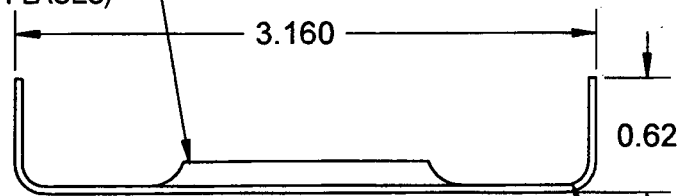


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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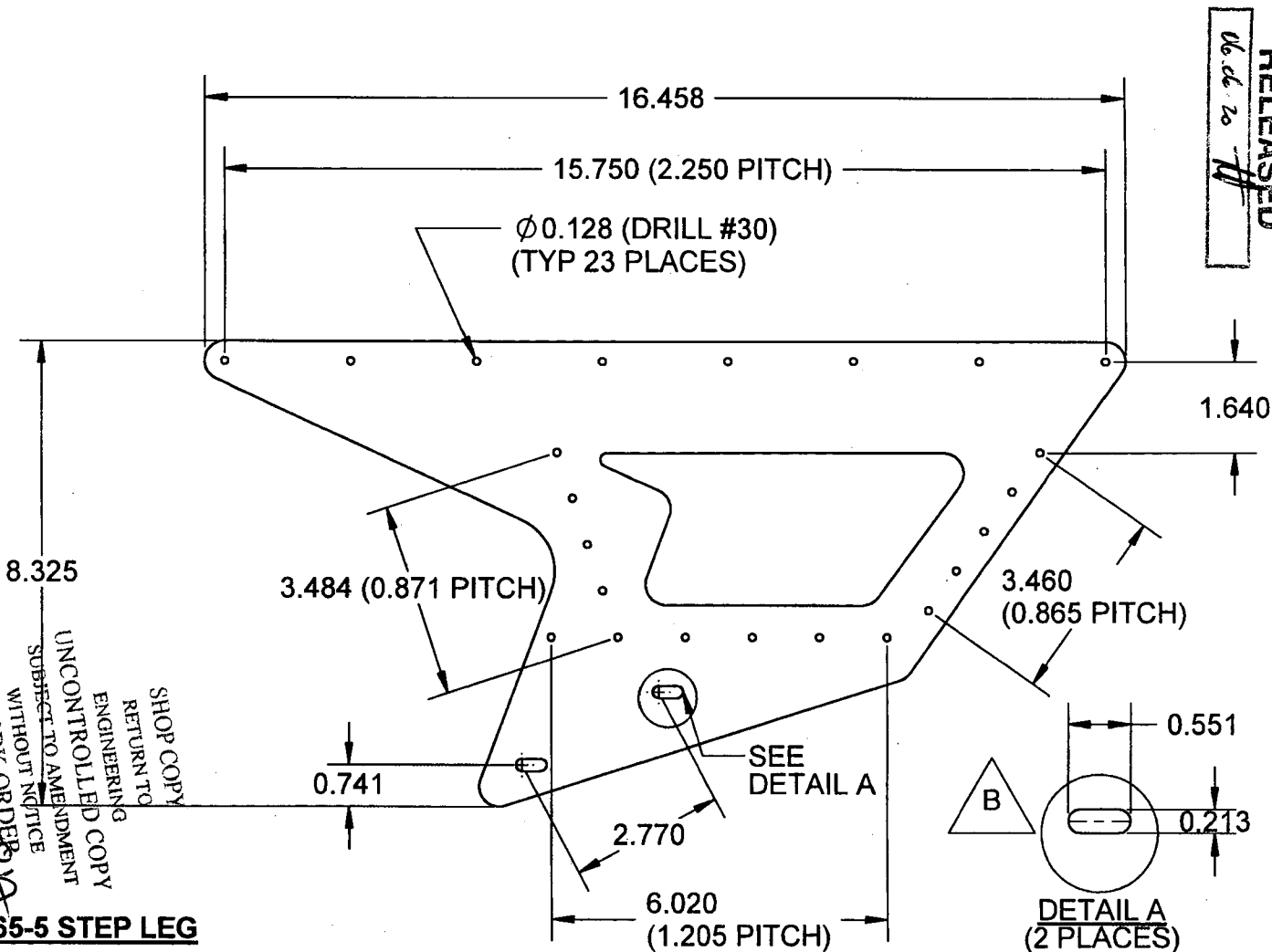
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CHECKED	PH	APPROVED	<i>[Signature]</i>	DRAWING NO. D3065
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY	
		SCALE	1:3	REV. B SHEET 4 OF 5

RELEASED



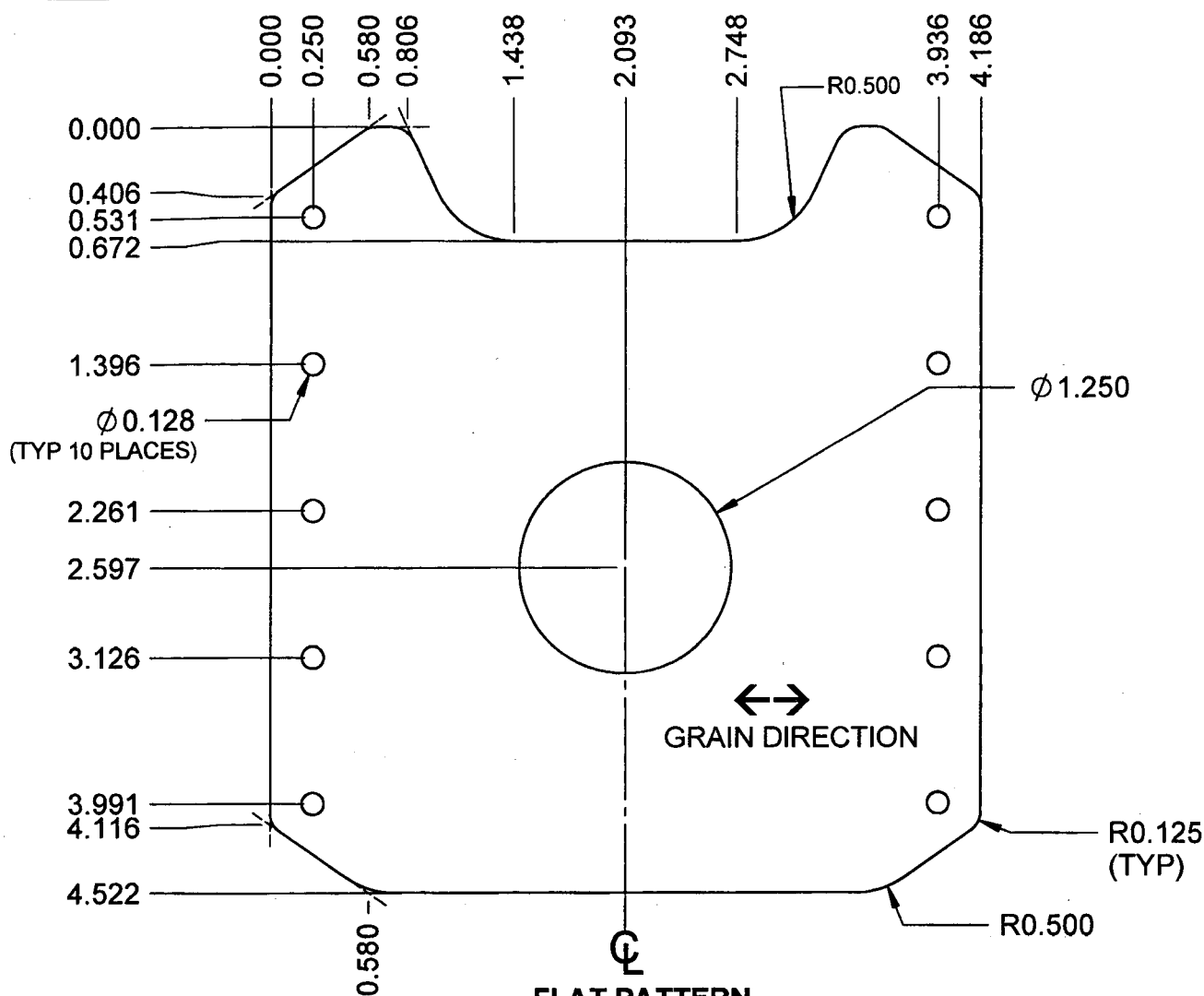
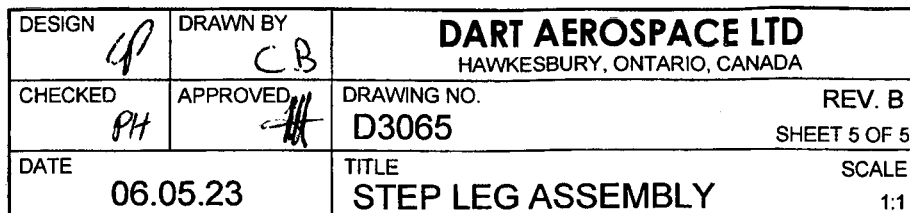
D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN

RELEASED

06 06 20

BEND DETAIL

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2024 T3S1040
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NO. 43858A

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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